

Date: Monday, 11/08/2008 10:20:15 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name: STA 84 BRACKET
 Job Number : 41079
 Estimate Number : 11034
 P.O. Number :
 This Issue : 11/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11/08/2008 Type : MACHINED PARTS
 Previous Run : 35851
 Part Number : D28031
 Drawing Number : D2803 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 26/08/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : JLD 08.8.11
 Comment : Est. A00.11.06 New Issue EC
 Est Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X10000 6061-T6 Bar .500 x 10.00



Comment: Qty.: 2.0125 f(s)/Unit Total: 24.1504 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: 105411

B 8-8-18

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per template DT8533

Dwg Rev: B

Prog Rev: B

B 8-8-18

⑫

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



⑪

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

H.A

08/09/09

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



⑪

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A

08/09/09

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/09/10

⑪

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2803-1 PAR #: N/A Fault Category: machined parts ~~Prod /~~ ~~the ass~~ ~~made~~ ~~small~~ NCR: (Yes) No DQA: D Date: 08/09/12
QA: N/C Closed: D Date: 08/09/12

NCR: <u>41079</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09	30	one part has the wrong thickness at 0.1085" instead of 0.125" "Section B-B on Dwg." R.C. Blank was cut too thin small on water jet. Blank was positioned to close to edge of finishing pass.		SCRAP PART 08-09-09 Destroy and no replace Qty (2)	M.A 08/09/09			
				Re-prog water jet to incorporate holes in blank to ensure proper Alignment.				

NOTE: Date & initial all entries

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Drawing Name: STA 84 BRACKET

Job Number: 41079

Part Number: D28031

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 52

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41079
Description: Bracket		Part Number: D2803-1
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

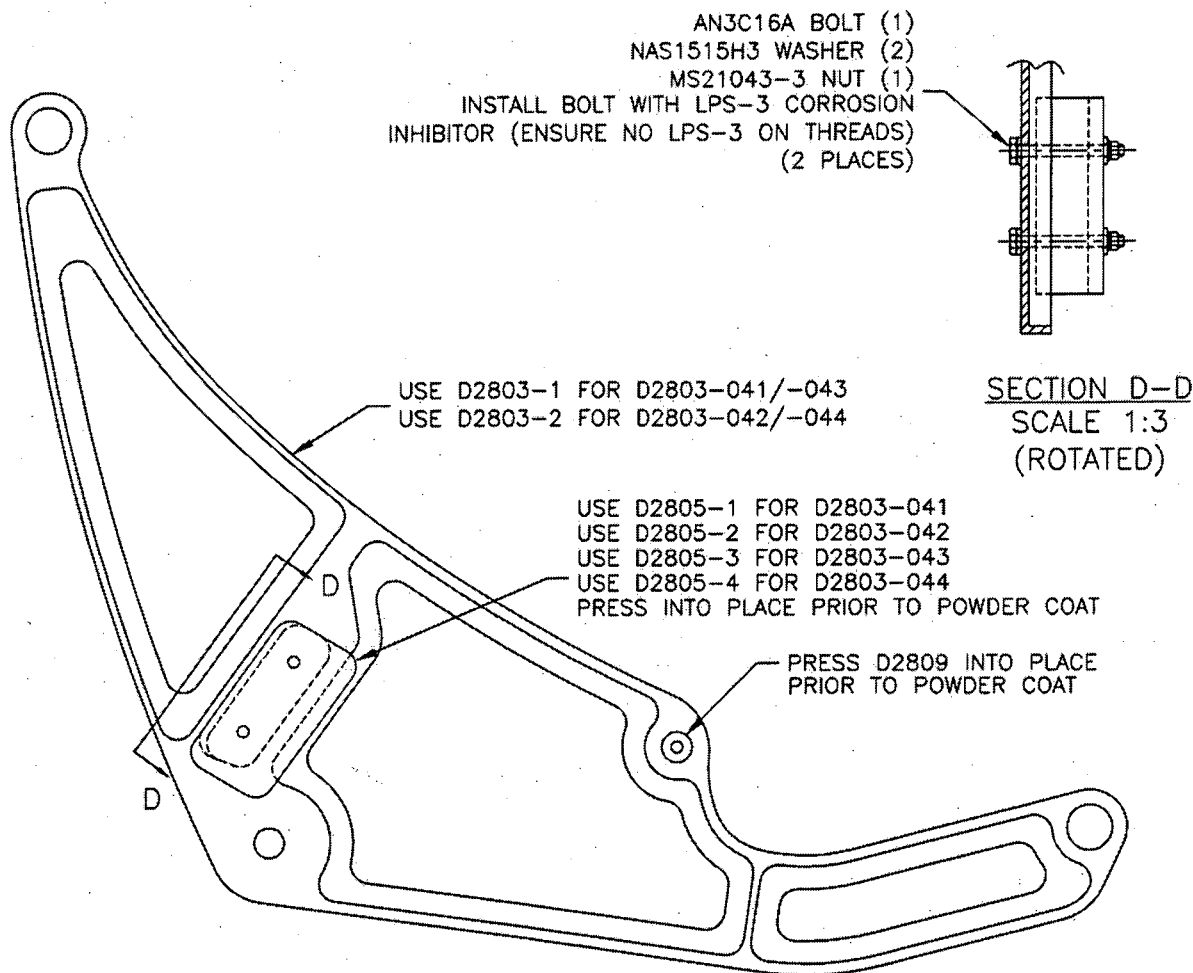
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø0.758	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
13.558	+/-0.010	13.558	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
12.411	+/-0.010	12.411	✓			
2.654	+0.000/-0.001	2.654	✓			
0.437	+0.000/-0.001	0.437	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	0.251	✓			
0.875	+0.000/-0.001	0.875	✓			
0.250	+0.000/-0.005	0.247	✓			
0.125	+/-0.010	0.128	✓			
0.125	+/-0.010	0.127	✓			
0.125	+/-0.010	0.127	✓			
0.125	+/-0.010	0.126	✓			
0.500	+/-0.010	0.501	✓			
0.562	+/-0.010	0.564	✓			
0.188	+/-0.010	0.189	✓			

Measured by: M.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/09/09	Date: 08/09/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM [Signature]	[Signature]



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA. 84 BRACKET	SCALE 1:3



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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 41079

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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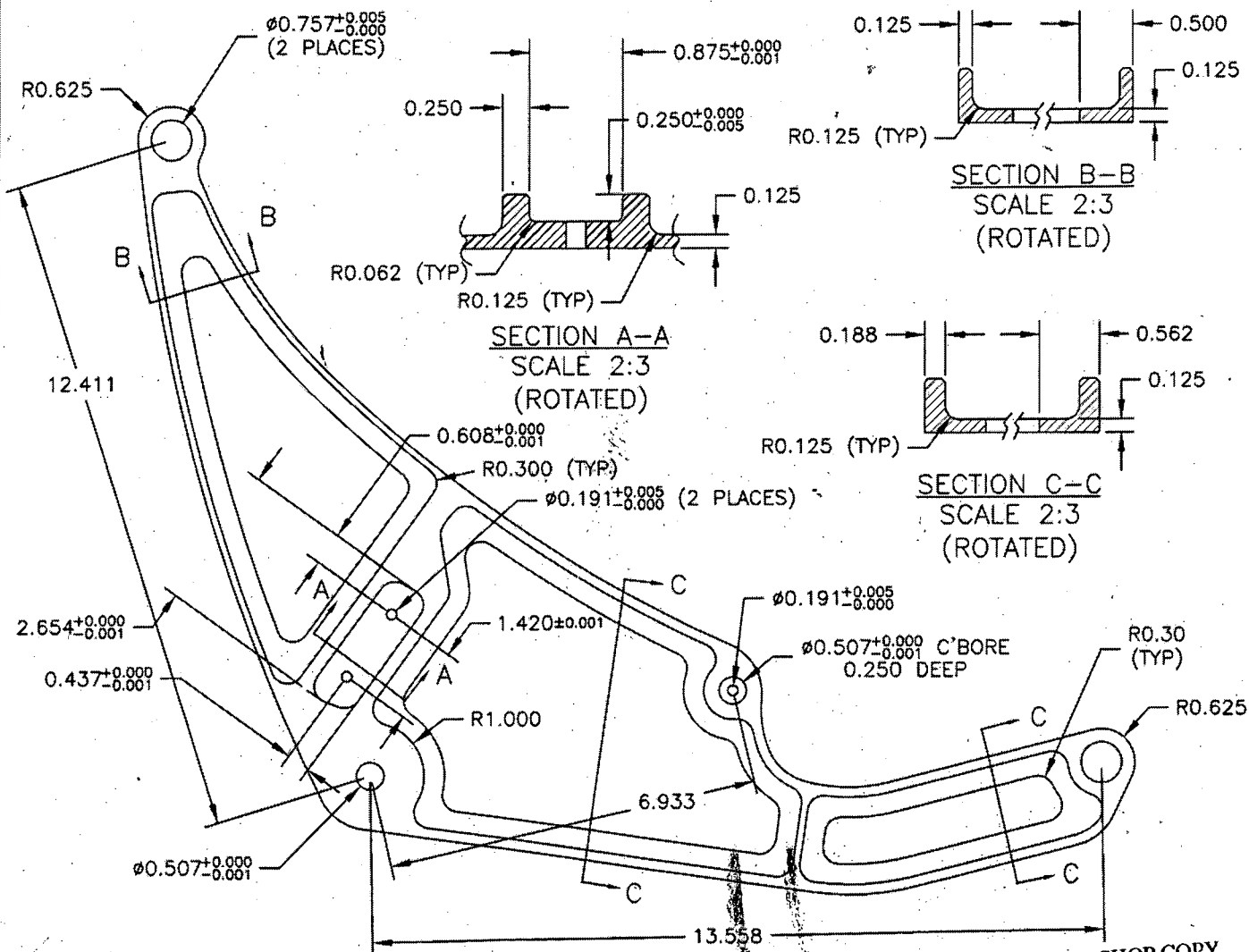
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03 11 [Signature]

**D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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